

Work Order ID 65994

Tuesday, February 01, 2011 8:40:25 AM

Page 1

Item ID: D350-600-249

Accept

Revision ID:

Item Name: Spacepod Upgrade

Start Date: 2/1/2011 Start Qty: 3.00

Required Date: 2/4/2011 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Pto =>

11/2/11

1102-03 Per E.D.
paper work 2 label.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-249 PAR #: _____ Fault Category: Prod-Eng-cancel NCR: Yes No DQA: ✓ Date: 11/02-03
 Resolution: done & sealed Disposition: rework QA: N/C Closed Date: 11/02/07

NCR: <u>65994</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/02	# 110	Found when checking kit to ITA that the wrong qty for AN960300 washer was on w/o pick list.	<u>DS/11/02/02</u>	- ADD qty of 8 AN960300 m to kit	<u>See w/o pick list</u>	<u>11/02-03</u>	<u>DS/11/02/03</u>	<u>11/02/07</u>
		w/o asks for a qty who should be at 24 per kit R.C. who not correctly create correctly to 72n.	<u>DS/11/02/02</u>	- correctly up into Bonit w/o to 72n. Add copy of verification form for reference	<u>11.02.07</u>	<u>11/02-07</u>	<u>DS/11/02/03</u>	<u>11/02/02</u>

NOTE: Date & initial all entries

Work Order ID 65994

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Item ID: D350-600-249

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacepod Upgrade

Start Date: 2/1/2011 Start Qty: 3.00

Required Date: 2/4/2011 Req'd Qty: 3.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00				11/2/11	SP		3x
	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-249 Location: <u>33</u> PPP Rev: <u>B</u>								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							
Quality Control									

OK 11/02/04
mr
11-02-04

Picklist Print

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue 07.01.31 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

A3235-020-935

Purchased

No

120

Each

460.0000

3

Washer - Countersunk

Location

Loc Qty

Loc Code

ST281

460

106150

460

AN526C832R10

Purchased

No

120

Each

165.0000

10

30

Screw

Location

Loc Qty

Loc Code

ST327

165

104603

3

113154

12

114382

50

115101

100

AN526C832R14

Purchased

No

120

Each

572.0000

6

18

Screw

Location

Loc Qty

Loc Code

ST327

572

104916

572

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Page 2

4

AN526C832R24

Purchased

No

110

Each

86.0000

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00



screw

Sf3



4 12

11/2/11

Location

Loc Qty

Loc Code

ST325

20

115518

20

ST327

66

110179

16

116556

50

1

11

AN5-5A

Purchased

No

120

Each

82.0000



Bolt

Sf3



1 3

11/2/11

Location

Loc Qty

Loc Code

ST337

82

110865

82

120

Each

8.0000

3

3

AN960JD10

NAS1149D0363J

Purchased

No



Washer

Sf3



1 3

11/16/25 11/2/11

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD10L

NAS1149D0332J

Purchased

No



Washer

Sf3



1 3

11/16/41 11/2/11

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Shop Packet Print

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

AN960JD516 NAS1149D0563J Purchased

No

120

Each

34.0000



Washer



4 12

M114742 11/2/11

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN960JD8 NAS1149DN832J Purchased

No

120

Each

10.0000



Washer



24 18 18 96

M116513 11/2/11

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2228

Manufactured

No

120

Each

54.0000



Bracket Plate



2 6

11/2/11

Location

Loc Qty

Loc Code

ST009

54

48228

12

64427

42

D2237

Manufactured

No

120

Each

60.0000



Striker Plate



1 3

11/2/11

Location

Loc Qty

Loc Code

ST009

60

64426

20

64762

40

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

D2464 Manufactured No 120 f 588.4934 3 9.473684



3/4 Seal

Location	Loc Qty	Loc Code
ST402	88.4934	
48173	88.4934	
ST404	500	
61878	500	

D3015-3 Manufactured No 120 Each 45.0000



Locknut

Location	Loc Qty	Loc Code
ST030	36	
64275	36	
ST033	9	
60287	9	

D3538-1 Manufactured No 120 Each 8.0000



Hinge Bracket

Location	Loc Qty	Loc Code
ST069	8	
59141	8	
ST069	11	
57951	11	

D3547-1 Manufactured No 120 Each 11.0000



Bracket

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

D3550-1

Manufactured No

120

Each

6.0000



Strut



1

3

11/2/11

Location

Loc Qty

Loc Code

ST271

6

56332

6

3

D3552-7

Manufactured No

120

Each

5.0000



Door Prop



1

3

11/2/11

Location

Loc Qty

Loc Code

ST272

5

65879

5

3

D3554-7

Manufactured No

120

Each

25.0000



Ball Stud



1

3

11/2/11

Location

Loc Qty

Loc Code

ST067

10

65123

10

ST070

15

37674

15

3

D3557-1

Manufactured No

120

Each

14.0000



Bracket



1

3

11/2/11

Location

Loc Qty

Loc Code

ST070

14

50283

2

64452

12

2

1

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

MS20426AD4-5

Purchased

No

120

Each

5,615.000



Rivet

Location

Loc Qty

Loc Code

ST317

5615

6733

633

6874

4982

120

Each

278.0000

MS21042L08

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

278

116513

278

120

Each

2,944.000

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

2944

114784

9

115835

435

116391

900

116540

800

116549

800

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: - Spacepod Upgrade

Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

MS21042L5

Purchased

No

120

Each

1,214.000

1 3



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1188

115594

492

116105

496

116548

200

MS24694-S69

Purchased

No

120

Each

87.0000

1 3



Screw

Location

Loc Qty

Loc Code

ST289A

87

112492

87

MS27039-08-11

Purchased

No

120

Each

65.0000

2 6



Screw

Location

Loc Qty

Loc Code

ST290

65

116289

65

MS27039-1-25

Purchased

No

120

Each

66.0000

1 3



Screw

Location

Loc Qty

Loc Code

ST292

66

102602

66

Picklist Print

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Work Order ID: 65994

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade



Start Date: 2/1/2011

Required Date: 2/4/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H3

Purchased

No

120

Each

158.0000



Washer



11/2/11 SP

30

Location

Loc Qty

Loc Code

ST277

158

115675

6

115935

52

116373

100

6

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™